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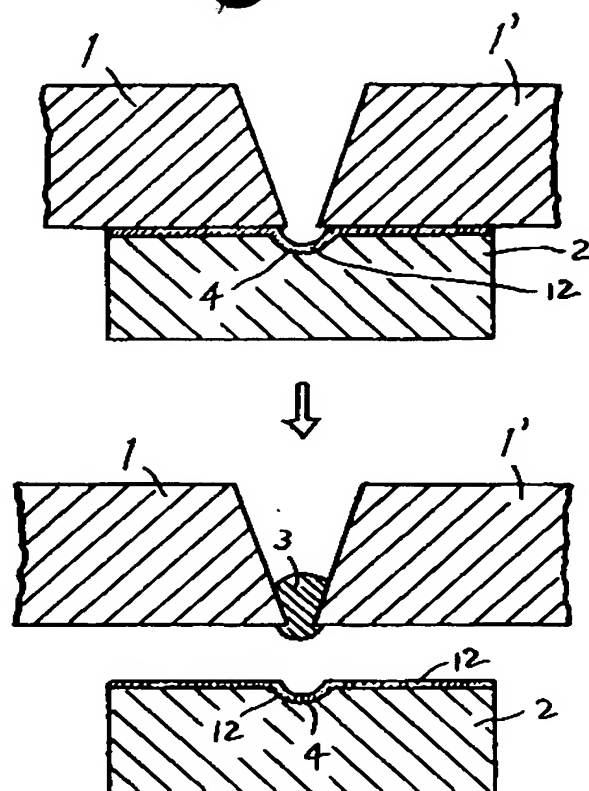
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TITLE : BACKING METHOD FOR ONE-SIDE  
WELDING



ABSTRACT : PURPOSE: To form a defectless penetration bead in the stage of performing one- side welding of metallic materials by using a backing strip by interposing a coating layer contg. a specific material having a laminar crystal lattice structure between the metallic materials to be welded and the backing strip.

CONSTITUTION: One-side welding of materials 1, 1' to be welded such as steel materials by using a backing strip 2 is accomplished by interposing a coating layer 12 contg. a material having a laminar crystal lattice structure such as boron nitride, graphite, graphite fluoride, tungsten disulfide, molybdenum disulfide or the like as an essential component between the materials 1, 1' and the strip 2 and subjecting these materials to one-side welding. The layer 12 has excellent heat resistance, electrical insulating characteristic and release property and therefore a penetration bead 3 which is free from defects such as a blowhole, undercut, overlap, etc. unlike the coating layer consisting of other materials and has excellent quality is easily formed. The layer 12 is repeatedly usable and is highly economical as well.

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